

Work Order ID 146803

146803

Page 1

Thursday, June 16, 2016 10:03:37 AM

Item ID: D4577-~~047~~ *du* Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: *du* Stop ***NS2***
 Item Name: Fwd Access Panel Assembly
 Start Date: 5/17/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/24/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4577	C

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.05							
FLOW CNC Waterjet	1-Cut D4577-5 as per Dwg Dwg Rev: <u>5</u> Prog Rev: <u>2</u> 2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
38
9-89
JUL 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 146803

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146803

Page 2

Item ID: D4577-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Access Panel Assembly
 Start Date: 5/17/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/24/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 36 9-89
130	NC BRAKE	0.00								
130										
Small Fab	Memo	0.02								
Small Fab	C'SINK HOLES AS PER DWG									
140	QC5- Inspect part completeness to step on W/O	0.00								
140										
QC	Memo	0.01								
Quality Control										
150	Chemical Conversion Coat per QSI005 4.1	0.00								
150										
HandFinish	Memo	0.03								
Hand Finishing										

6X 16/07/12

6 DAS 38 9-89 JUL 13 2016

6 233 2016/07/13 BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Thursday, June 16, 2016 10:03:37 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/17/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00 *1*

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

160

0.01

JUL 14 2016

0.00

170

0.04

Assemble as per dwg

0.00

180

0.01

JUL 15 2016

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 146803

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146803

Page 4

Item ID: D4577-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Access Panel Assembly

Start Date: 5/17/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Identify as per dwg & Stock Location: <i>W1503</i>	0.00					DAS 6 9-89		
220									
Packaging	Memo	0.01							JUL 15 2016
Packaging									
							DAS 21 9-89		JUL 18 2016
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.07					DAS 21 9-89		JUL 18 2016
Quality Control									
							DAS 21 9-89		JUL 15 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, June 16, 2016 10:03:36 AM

Page 1

Work Order ID: 146803

146803

Parent Item: D4577-041

D4577-041

Parent Item Name: Fwd Access Panel Assembly

Start Date: 5/17/2016

Required Date: 5/24/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B
12.04.25 AS PER DWG REV.B DD VERF:EC IPP REV:C 15.01.15
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

78.0000

0.767

3.229474

M6061T6S 125

6061-T6 .125 Sheet

**

PR 2016/07/11

Location

Loc Qty

Loc Code

MAT020

78

m134217

14

m134696

32

m134982

32

4.1

MS20426AD3-5

Purchased

No

170

Each

4,357.000

10

40

MS20426AD3-5

Rivet

**

16/07/14

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

4118

4533

4118

ST312

239

4444

239

50

NAS1474R3

Purchased

No

170

Each

30.0000

5

20

NAS1474R3

Anchor Nut

**

16/07/14
DAS
36
9-89

Location

Loc Qty

Loc Code

ST260

30

m127904

30

30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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OTHER : _____																									



RELEASED
2015 JAN 15 *up*

- NOTES:**
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.06 lbs

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	SHEET 4 OF 4
	MFG. APPR.	DD	D4577	
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	ACCESS PANEL	NTS
	DATE	14.12.05		